

Date: Tuesday, 1/15/2008 3:04:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212 X-TUBE LOW NARROW AFT
 Job Number : 36644
 Estimate Number : 13019
 P.O. Number :
 This Issue : 1/15/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D212664207
 First Issue : 1/7/2008 Type : LANDING GEAR Drawing Number : D212-664-247-~~UR~~ A
 Drawing Revision : ~~UR~~ A
 Material :
 Due Date : 2/5/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 08 01.15
 Comment : Est Rev: A New Issue 07.09.12 EC verified by: JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-207 CHG001

2.0 D6008132 Crosstube extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6008-132 Crosstube 3290 32920

Check OD = 3.250"; ID = 2.375"

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: 1-TURN AS PER FOLIO FA706 & DWG D212-664-247,

FOLIO REV: ADWG REV: A

2-DEBURR AS REQUIRED

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/15/2008 3:04:53 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE LOW NARROW AFT

Job Number: 36644

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



AWM 05-01-23



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

7.0

QC5

INSPECT WORK TO CURRENT STEP



8-1-24



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 8-1-24



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3/5

INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

Am 08.01.26

①

10.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-247 using CNC bender program and Folio FT

Am/EL 08.01.26 ①

11.0

QC6

DIMENSIONAL CHECK



08-02-01 ①



Comment: DIMENSIONAL CHECK

12.0

D36601

CUFF



Comment: Qty: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

CUFF

Batch: B36 835

② 8-2-7

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1.1 Cut tube to height - EL/50 8-2-4

1.2 Drill Rivet holes as per Dwg D212-664-247 using DT8972

2-Drill pilot holes in tube as per Dwg D212-664-247

3-Ream hole to finish size in tube as per Dwg D212-664-247

Am/ 8-2-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW NARROW AFT

Job Number: 36644

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-247

AWM 8-2-7

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 8-2-7



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION:

08/02/14

(4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/14 (4)

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 5729 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C208/02/19 (1)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

12/4/15 (1)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

20.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D212-664-247. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291 BATCH: M105 585

EL 8-2-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE LOW NARROW AFT

Job Number: 36644

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

CR3212406

CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

CHERRY RIVET

Batch: M104156

EL 8-2-20

①

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

RT 06-02-20

23.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

M 08 02 22

①

24.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support

batch: 32780

M 08 02 22

25.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.8295 sf(s)/Unit Total : 0.8295 sf(s)

Rubber Cushion

Cut to .630" X 5.3" Qty 4

Batch: 35125

M 08 02 22

26.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

Batch: 106864

M 08 02 22

27.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M106516

SP/2 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 212 X-TUBE ,LOW NARROW AFT

Job Number: 36644

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0
30

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch M104427

29.0
31

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch M105077

30.0
32

AN960JD616

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

batch M106883

31.0
33

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

batch 34909

32.0
27

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D212-664-247

Instal support with magnobond 6398 per dwg D212-664-247,
cure for 12hrs before packaging.

Time & date of application: 9:30AM 08/02/22

Batch: 105379 exp: 05/2008

M1080222

(1)

33.0
20

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Done

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 20/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW NARROW AFT

Job Number: 36644

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0
35

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-207

Rev A AS 08/2/27 (1)

36.0
36

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/02/27 (1)

Job Completion



mi 2008/2/27 (1)

34.0) QCY AS 08/2/27 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	366A4
Description: Crosstube Assembly (205/212 Low Aft)		Part Number:	D212-664-247
Inspection Dwg: D212-664-247 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

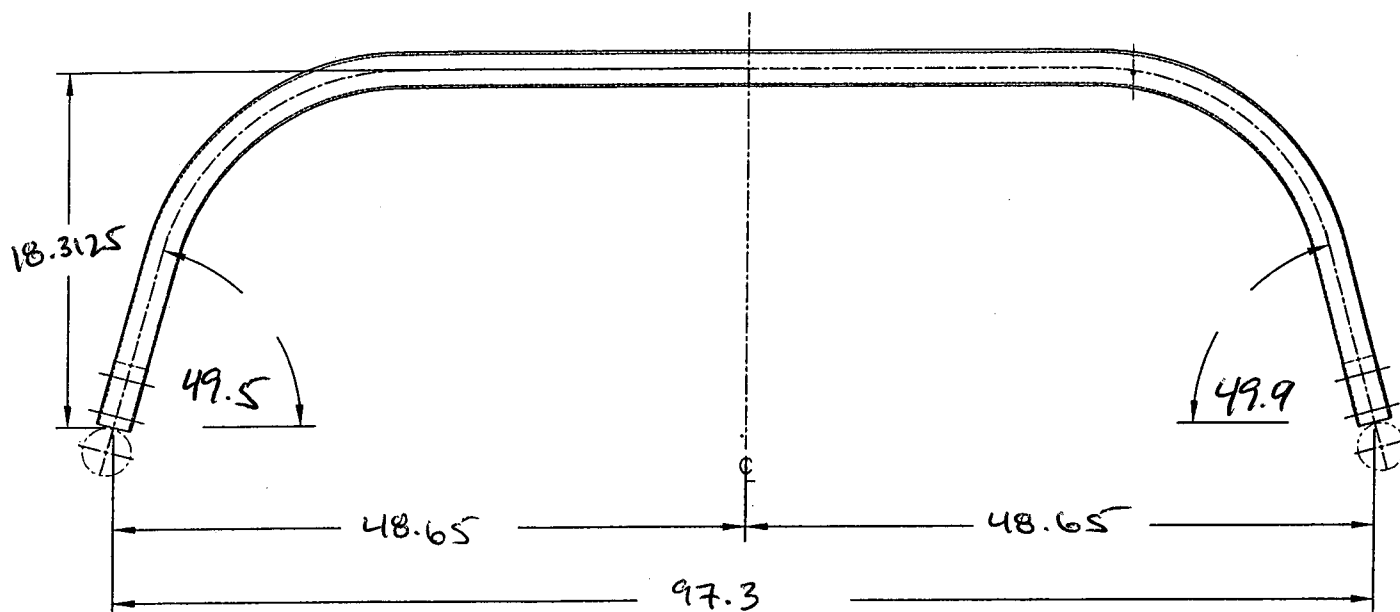
☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.680	+/- .010	2.682				
	2.680	+ .005 - .00	2.682				
	2.687	+ .005 - 0.0	2.684				
	2.802	+ .005 - 0.0	2.806				
	2.906	+ .005 - 0.0	2.909				
	3.009	+ .005 - 0.0	3.011				
	3.112	+ .005 - 0.0	3.116				
SIDE B	128.27	+/- .020	128.26				
	2.680	+/- .010	2.682				
	2.680	+ .005	2.684				
	2.687	+ .005	2.691				
	2.802	+ .005	2.806				
	2.906	+ .005	2.909				
	3.009	+ .005	3.011				
	3.112	+ .005	3.116				

Measured by: <i>RG</i>	Audited by: <i>RF</i>	Prototype Approval:	N/A
Date: <i>08/01/23</i>	Date: <i>08/01/23</i>	Date:	N/A
Rev	Date	Change	Revised by
A		New Issue (P/O D212-664-207)	KJ/EC/DD
			Approved

DART AEROSPACE LTD		Work Order:	36644
Description: Crosstube Low Aft (205/212)		Part Number:	D212-664-207
Inspection Dwg: D212-664-247 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	18.16	18.42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



Comments

QC15 Inspection	<i>[Signature]</i>
Date	08-02-01

Rev	Date	Change	Revised by	Approved
A		New Issue		<i>[Signature]</i>

PARTS LIST:

Qty	Part Number	Description
X	D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
1	D6008-132	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
2	D3660-1	CUFF
4	MS21920-28	CLAMP (OR MS21920-30)
44	CR3212-4-06	RIVET (OR M7885/3-4-06)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6008-132
FINISHED LENGTH = 128.27±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK. BLEND OUT EDGE LONGITUDINALLY.
TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER ON INNER SURFACE OF TUBE WITH A
VIBRATING STYLUS.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1
THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE
D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY
AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A
LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN
CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

RELEASED
07.09.24 #

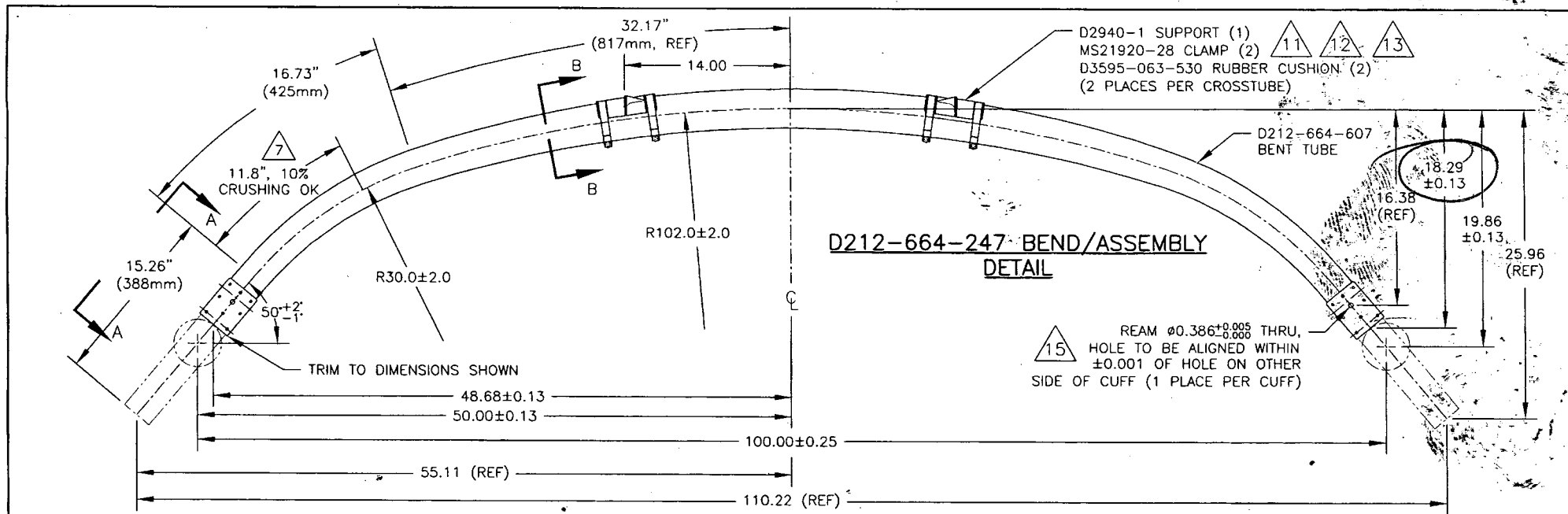
NO 20644
WORK ORDER
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A		07.07.07	NEW ISSUE
DESIGN	90	DRAWN BY	90
CHECKED		APPROVED	DART
DATE		DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA	
07.07.07		DRAWING NO.	REV. A
		D212-664-247	SHEET 1 OF 3
		TITLE	SCALE
		CROSSTUBE (205/212 LOW AFT)	MTS

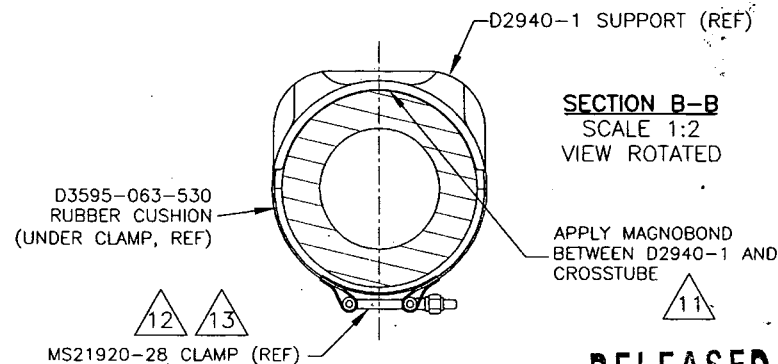
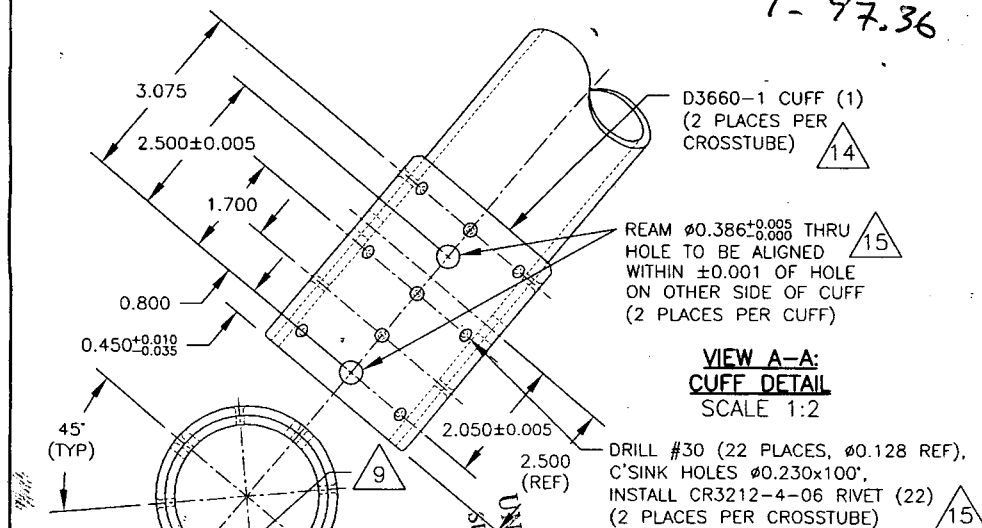
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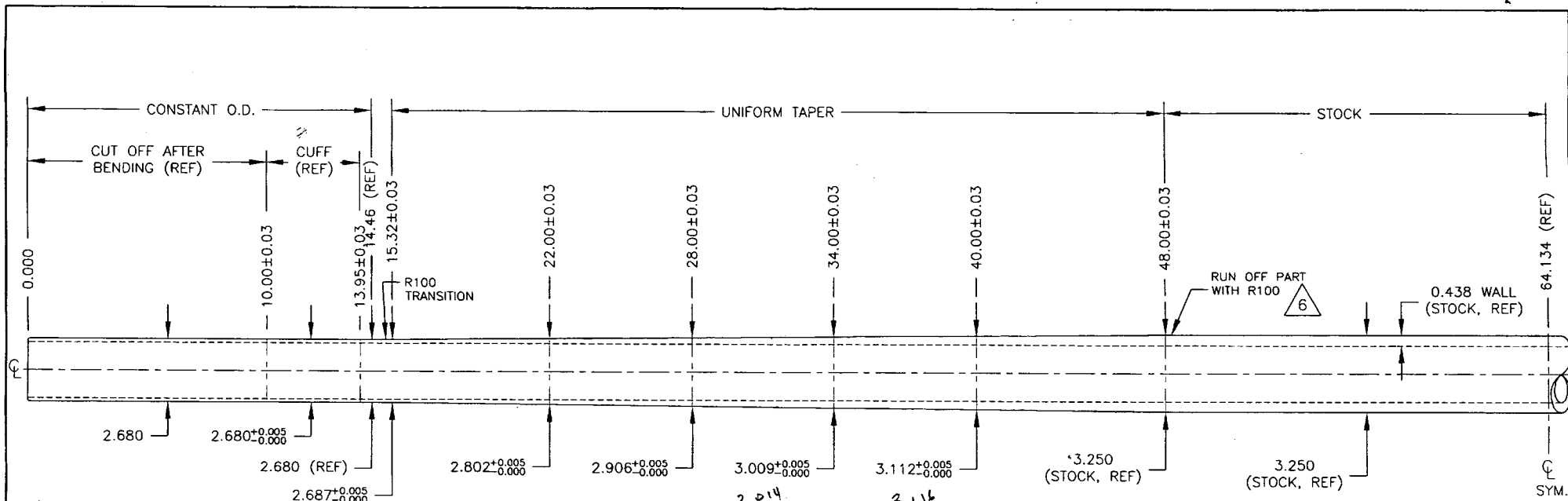


T- 97.36



RELEASED
07.07.07

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		DATE	07.07.07			TITLE CROSSTUBE (205/212 LOW AFT)	SCALE 1:8



D212-664-247 MACHINING DETAIL

RELEASED
07.07.24

NO. 36644
WORK ORDER
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DATE		07.07.07		DRAWING NO.	REV. A
				D212-664-247	SHEET 3 OF 3
				TITLE	SCALE
				CROSSTUBE (205/212 LOW AFT)	1:4



LIQUID PENETRANT TEST REPORT

P- 09830

PAGE 1 OF 1

CLIENT Dart AREOSPACE DATE Feb 15, 2008 TIME AM ☐ PM ☐
ATTENTION Linda Lucelle ACUREN JOB NO. 188-08-1220
ADDRESS 1270 Aberdeen st. POWO No. _____
Hawkesbury ontario WORK LOCATION Hawkesbury
ACCEPTANCE STD. ASTM 1417/AS1-03B REV./DATE 2005
PROJECT 212 X-TUBE, LOW NARROW AFT and FWD, 407 HIGH AFT X-TUBE ASSEMBLY, 412 X-TUBE LOW NARROW AFT
ITEM(S) EXAMINED Job# 36642 - 36644 - 36645 - 36768 - 36770 - 36773 - 37009 - 37010

JOB DESCRIPTION _____ PROCEDURE NO. LT-XXXX REV./DATE _____ TECHNIQUE No. LT-XXXX-XXX REV./DATE _____
PART No. D012664107-D012664307-D012664308-D012664309-D012664310 MATERIAL ALLOYED ALUMINUM
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND Magnaflux BLACK LIGHT S/N 8178 ☒ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2LG7 MINIMUM DWELL TIME 405 MIN. LIGHTING EQUIP. ☒ FLASHLIGHT ☐ TROUBLELIGHT ☒ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER _____
DEVELOPER SKDS2 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N _____ CAL DUE DATE MAR 08
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☒ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☐ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)			
ITEM	COMMENTS	ACCEPT	REJECT
Job# 36642	ACCEPTABLE		
36644	ACCEPTABLE		
36645	ACCEPTABLE		
36768	ACCEPTABLE		
36770	ACCEPTABLE		
36773	ACCEPTABLE		
37009	ACCEPTABLE		
37010	ACCEPTABLE		

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Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Matthew Murdoch SIGNATURE Matthew Murdoch DTR # _____
TECHNICIAN (SIGNATURE): Chagnon Frederick SIGNATURE Chagnon Frederick
NAME (PRINT): Chagnon Frederick 1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL II SNT LEVEL _____ CGSB LEVEL _____ SNT LEVEL _____
CGSB REG. No 10560 CGSB REG. No _____